

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008735**Date Inspected:** 21-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #002 located on Cross Beam CB202F – 015. Welder is identified as 207345. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

FCAW process welding of weld joint #054 located on Floor Beam FB204 – 013. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #001 located on Cross Beam CB202F – 015. Welder is identified as 059450. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

BAY 2

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This QA Inspector observed the following work in progress:

SAW process welding of weld joint #081 located on Floor Beam FB3056 – 001. Welder is identified as 250050. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

FCAW process welding of weld joint #007 located on Floor Beam FB3005 – 006. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SAW process welding of weld joint #101 located on Floor Beam FB3054 – 001. Welder is identified as 250050. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

FCAW process welding of weld joint #015 located on Floor Beam FB3005 – 006. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 6

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. BP3008 - 001 - 008~019; 044~055 – Green Tag # 10394
2. SP3016 - 001 - 011~020; 021~030 – Green Tag # 10393

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #45 located on WD1 – A305 – 65M – 1. Welder is identified as 066481. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #9B located on WD1 – A305 – 65M – 3. Welder is identified as 037780. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #021 located on Side Plate SP3026 – 017. Welder is identified as 048625. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SMAW process welding of weld joint #004 located on DP3036 – 017. Welder is identified as 250833. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B –

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P – 2112.

FCAW process welding of weld joint #057 located on Side Plate SP3026 – 017. Welder is identified as 048625. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SMAW process welding of weld joint #008 located on DP3035 – 017. Welder is identified as 250489. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
